
वस्त्रादि — सादे केलिको करघों के लिए
शेडिंग टैपेट — विशिष्टि

(पहला पुनरीक्षण)

**Textiles — Shedding Tappets for
Plain Calico Looms — Specification**

(*First Revision*)

ICS 59.120.30

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FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Textile Machinery and Accessories Sectional Committee had been approved by the Textiles Division Council.

This standard was originally published in 1978. The standard has again been revised to incorporate the following changes:

- a) References to Indian Standards have been updated;
- b) Marking clause has been modified; and
- c) Packing clause has been incorporated.

The composition of the Committee responsible for the formulation of this standard is given in Annex A.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian Standard***TEXTILES — SHEDDING TAPPETS FOR PLAIN CALICO LOOMS — SPECIFICATION***(First Revision)***1 SCOPE**

This standard prescribes requirements for shedding tappets for plain calico looms.

2 REFERENCES

The standards given below contain provisions which through reference in this text, constitute provision of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent edition of the standards:

| <i>IS No.</i> | <i>Title</i> |
|--|--|
| IS 2500 (Part 1) : 2000/ ISO 2859-1 : 1999 | Sampling procedures for inspection by attributes: Part 1 Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection (<i>third revision</i>) |

3 MANUFACTURE**3.1 Material**

Cast iron, cast steel or any other suitable material as agreed between the buyer and the seller meeting the requirements specified in 3.2 and 3.3, shall be used.

3.2 Freedom from Defects

Tappets shall be sound, clean and free from blow holes, hard spots and other harmful defects.

3.3 Test Bars

The test bars shall be cast separately. They shall be poured at the same time and from the same ladle of metal as the components they represent.

4 REQUIREMENTS**4.1 Dimensions and Shape**

The shape and dimensions of tappets (including split-type) shall be as agreed between the buyer and the seller according to the make of loom. A typical shedding tappet is shown in Fig. 1.

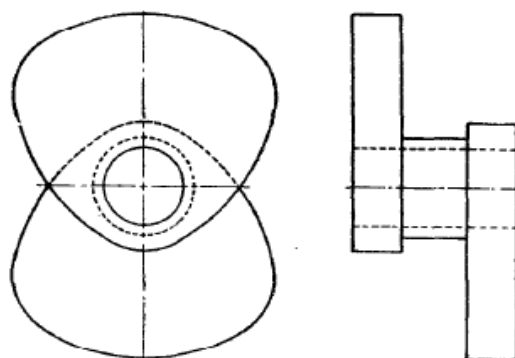


FIG. 1 TYPICAL SHEDDING TAPPET

4.2 Tensile Strength

Tensile strength shall meet the requirements as given in Table 1.

4.3 Hardness

The Brinell hardness of tappets shall be 200 HB to 220 HB.

5 SAMPLING

Unless otherwise agreed to between the buyer and the seller, to ascertain the conformity of tappets to the requirements of this specification single sampling plan with inspection level I and acceptable quality level (AQL) of 2.5 percent given in Table 1 and Table 2 of IS 2500 (Part 1) shall be followed.

6 MARKING

6.1 Each case/carton of tappet shall bear the following information:

- a) Manufacturer's name or trade-mark;
- b) Dimension of tappet;

- c) Material of tappet;
- d) Number of tappets;
- e) Gross and net mass;
- f) Lot/batch number;
- g) Country of origin; and
- h) Any other information required by the law in force and/or by the buyer.

6.2 BIS Certification Marking

The product conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the product may be marked with the Standard Mark.

7 PACKING

Tappet shall be packed in cases/cartons strong enough to withstand normal hazards of storage and transport. Details of the packing shall be as agreed to between the buyer and the seller. Packaging of the product shall be such as to maintain the integrity of the product throughout its shelf life.

Table 1 Tensile Strength

(Clause 3.2)

| SI No. | Sectional Thickness of Component | Diameter of Test Bar Cast | Tensile Strength |
|--------|-------------------------------------|------------------------------|--|
| | mm | mm | MN/m ² (kgf/mm ²) |
| (1) | (2) | (3) | (4) |
| i) | Up to 8 | 13 | 274.5 (28) |
| ii) | Over 8 and up to 15 | 20 | 254.9 (26) |
| iii) | Over 15 and up to 30 | 30 | 245.1 (25) |
| iv) | Over 30 and up to 50 | 45 | 215.7 (22) |

ANNEX A*(Foreword)***COMMITTEE COMPOSITION**

Textile Machinery and Accessories Sectional Committee, TXD 14

| <i>Organization</i> | <i>Representative(s)</i> |
|--|--|
| Central Manufacturing Technology Institute, Bengaluru | DR NAGAHANUMAIAN (Chairperson) |
| Amritlakshmi Machine Works, Mumbai | SHRI N. K. BRAHMACHARI SHRI N. K. RAUT (<i>Alternate</i>) |
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| Confederation of Indian Textile Industry, New Delhi | SHRI AJAY KUMAR |
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| ICAR-Central Institute for Research on Cotton Technology, Mumbai | DR N. SHANMUGAM DR T. SENTHILKUMAR (<i>Alternate</i>) |
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| Kusters Calico Machinery Limited, Karjan | SHRI DEVANG PARIKH SHRI SHUBHASIS SUR (<i>Alternate</i>) |
| Lakshmi Machine Works Limited, Coimbatore | MS KALPANA A. MS DIVYA V. (<i>Alternate</i>) |
| Laxmi Shuttleless Looms Private Limited, Ahmedabad | SHRI KETAN SANGHVI |

| <i>Organization</i> | <i>Representative(s)</i> |
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| Office of the Textile Commissioner, Mumbai | SHRI C. R. KALESAN SHRI JAGRAM MEENA (<i>Alternate</i>) |
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| Technocraft Industries India Limited, Mumbai | SHRI RAVINDER KUMAR SHRI DURADUNDESHWAR HIREMATH (<i>Alternate</i>) |
| Textile Machinery Manufacturers Association, Mumbai | SHRI M. SHANKAR SHRI PRASHANT MANGUKIA (<i>Alternate</i>) |
| The Bombay Textile Research Association, Mumbai | SHRI VIJAY GAWDE SHRI R. A. SHAIKH (<i>Alternate</i>) |
| The Synthetic and Art Silk Mills Research Association, Mumbai | DR MANISHA MATHUR SHRI SANJAY SAINI (<i>Alternate</i>) |
| The Textile Association (India), Mumbai | SHRI J. B. SOMA SHRI ASHOK JUNEJA (<i>Alternate</i>) |
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Member Secretary
SHRI SWAPNIL
SCIENTIST 'B'/ASSISTANT DIRECTOR
(TEXTILES), BIS

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Amendments Issued Since Publication

| Amend No. | Date of Issue | Text Affected |
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